

Date: Wednesday, 2/6/2008 11:12:18 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: FLOOR PROTCTOR AFT LH	
Job Number	: 37253		Part Number	: D32813	
Estimate Number	: 11228		Drawing Number	: D3281 REV.B	
P.O. Number	:		Project Number	: N/A	
This Issue	: 2/6/2008	S.O. No. :	Drawing Revision	: B	
Prsht Rev.	: NC		Material	:	
First Issue	: / /	Type :	Due Date	: 2/18/2008	
Previous Run	: 37110		Qty:	10 Um: Each	
Written By	:		Z		
Checked & Approved By	:				
Comment	: Est Rev A 04.07.01 New issue KJ/JLM Est Rev B 07.08.07 Thermoform in house DL				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	F6006 701	lexan black
Comment: Qty.: 4.0000 sf(s)/Unit Total : 40.0000 sf(s) lexan black		M106995
2.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
3.0	THERMOFORMING	THERMOFORMING MACHINE
Comment: THERMOFORMING MACHINE		
Thermoform as per Dwg. D32811and Folio FTA 009		
Dwg. Rev. <u>S</u> Folio Rev. <u>B</u>		
4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		
5.0	HAND FINISH TH	HAND FINISHING THERMOFORMING
Comment: HAND FINISHING THERMOFORMING		
1) Trim to Finished Dimensions		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 08/03/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 2/6/2008 11:12:18 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTCTOR AFT LH

Job Number: 37253

Part Number: D32813

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

1) Check Surface finish for undesired marks, voids, dimples etc.

BB 08/02/06

2) Check dimensions to ensure conformity to drawing tolerances.

7.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

5 08/03/03

8.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

ST 2606

AS 08/03/04

(X7)

9.0 QC21

FINAL INSPECTION/W/O RELEASE



8

7

Comment: FINAL INSPECTION/W/O RELEASE

08/03/04

Job Completion



h 08/03/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	37253
Description:	Part Number:	D3281-3
Inspection Dwg:	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

THERMOFORMING SECTION

Description	Accept	Reject	Method of Inspection	Comments
Inside Radii less than <u>3 16</u> "	✓			
Shape Definition	✓			
Texture Retention	✓			
Material imperfections such as bumps, cracks, voids, scratching	✓			

Measured by: BB

Date: 08/02/27

TRIMMING SECTION

Measured by:

Date: 08/03/27

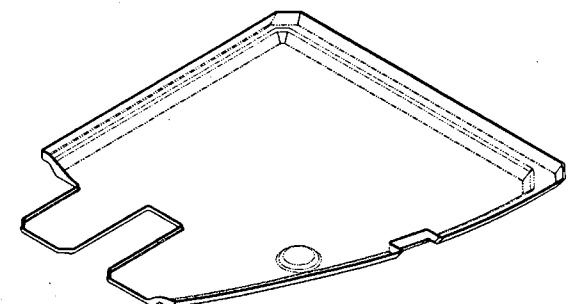
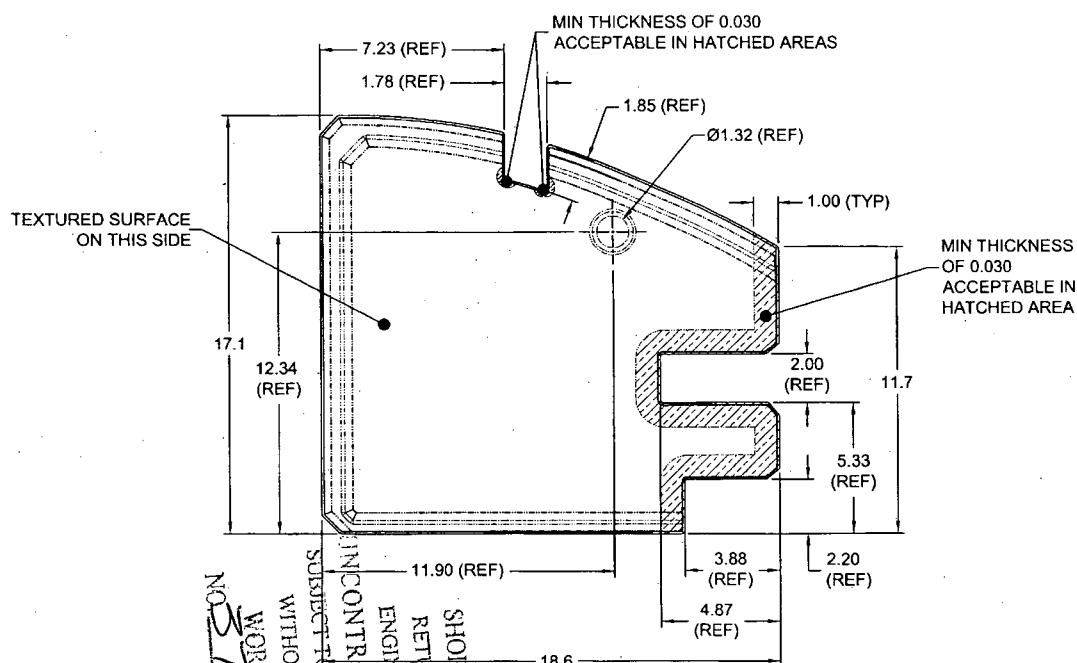
Audited by:

Date: 09/08/03

Prototype Approval:

Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/DL	



D3281-1 FLOOR PROTECTOR

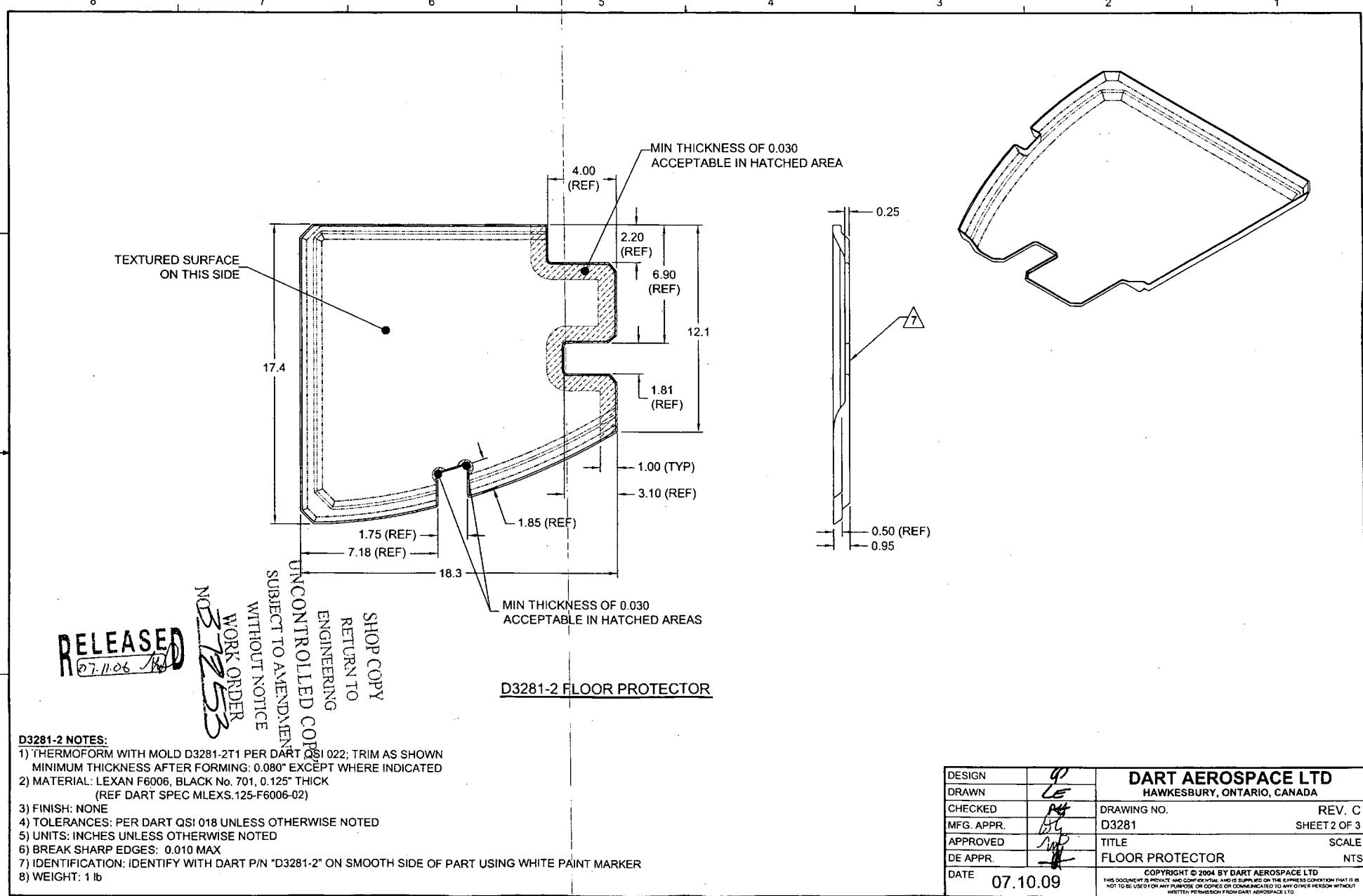
RELEASED
07-11-06

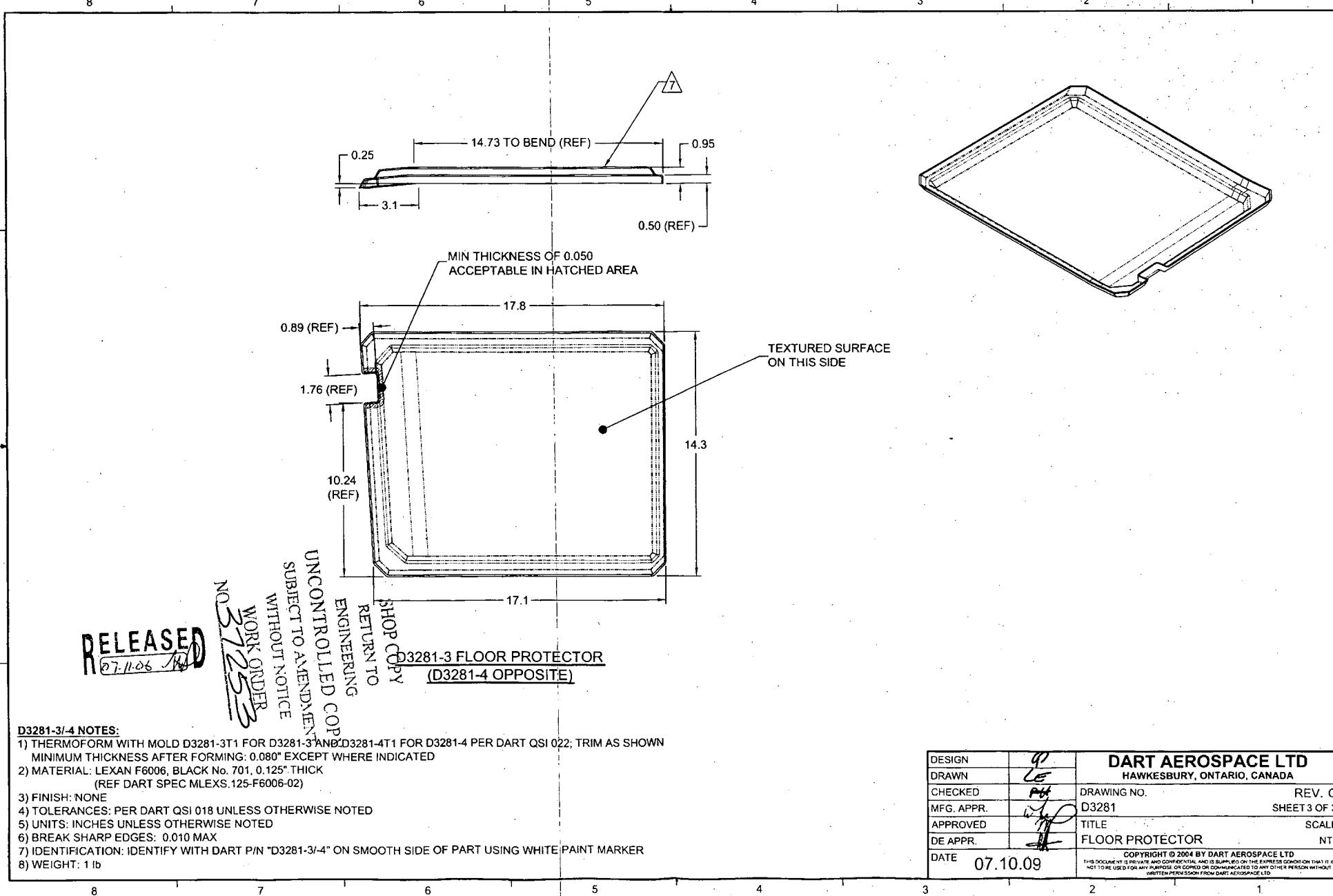
REMARKS
ENGINEERING
INCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 37253

D3281-1 NOTES:

- 1) THERMOFORM WITH MOLD D3281-1T1 PER DART QSI 022; TRIM AS SHOWN
MINIMUM THICKNESS AFTER FORMING: 0.080" EXCEPT WHERE INDICATED
- 2) MATERIAL: LEXAN F6006, BLACK No. 701, 0.125" THICK
(REF DART SPEC MLEXS.125-F6006-02)
- 3) FINISH: NONE
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.010 MAX
- 7) IDENTIFICATION: IDENTIFY WITH DART P/N "D3281-1" ON SMOOTH SIDE OF PART USING WHITE PAINT MARKER
- 8) WEIGHT: 1 lb

C	UPDATE DIMS TO MATCH PARTS; COLOUR 701 WAS 700; GENERAL UPDATE	LE	07.10.09
B	NOW LEXAN; DIMS AS MANUFACTURED	CP	05.11.25
A	NEW ISSUE	CP	04.05.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>9</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	<i>LE</i>		
CHECKED	<i>ps</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>LG</i>	D3281	SHEET 1 OF 3
APPROVED	<i>WJ</i>	TITLE	SCALE
DE APPR.	<i>WJ</i>	FLOOR PROTECTOR	
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE LTD.	





DESIGN	90	DART AEROSPACE LTD	
DRAWN	CE	HAWKESBURY, ONTARIO, CANADA	
CHECKED	PF	DRAWING NO.	REV. C
MFG. APPR.	W	D3281	SHEET 3 OF 3
APPROVED	W	TITLE	SCALE
DE APPR.	W	FLOOR PROTECTOR	NTS
DATE	07.10.09	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	